

Date: Monday, 14/04/2008 1:07:35 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CONSOLE BRACKET HI-SLOPE
Job Number : 38590	
Estimate Number : 11004	
P.O. Number :	Part Number : D2606
This Issue : 14/04/2008 S.O. No. :	Drawing Number : D2606 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A1
Previous Run : 36081	Material :
Written By :	Due Date : 30/04/2008 Qty: 20 Um: Each
Checked & Approved By : <u>JLD 08.4.14</u>	
Comment : Est. D 98.11.26 Added Inspection DM Est Rev:E Now On Waterjet 07-03-22 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.1582 sf(s)/Unit Total: 3.1647 sf(s)

2024-T3 .040 sheet

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

Stack of 10

(M2024T3S.040) Batch 107572 IB 8-4-16

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2606

Dwg Rev: A1

Prog Rev: A1

IB 8-4-16

(27)

2-Deburr if necessary

IB 8-4-16

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-4-16

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08/04/27 x 22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 14/04/2008 1:07:35 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE BRACKET HI-SLOPE

Job Number: 38590

Part Number: D2606

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
Deburr
Form as per Dwg D2606

SB 08/04/21

(27)

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

countes
08/04/22 (27)

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

08-04-22

(27)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-04-22 (27)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST38

08/04/22 (27)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/23

Job Completion



mf 08-04-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	38590
Description: Console Bracket		Part Number:	D2606
Inspection Dwg: D2606 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.841	+/-0.005	.841	*			
1.589	+/-0.005	1.589	*			
0.621	+/-0.010	.621	*			
1.809	+/-0.010	1.809	*			
2.430	+/-0.010	2.433	*			
0.621	+/-0.010	.621	*			
8.309	+/-0.010	8.309	*			
8.930	+/-0.010	8.930	*			
8.710	+/-0.010	8.710	*			
R0.250	+/-0.010	.250	*			
R0.156	+/-0.010	.156	*			
Ø0.098	+0.005/-0.000	.102	*			
0.040	+/-0.005	.040	*			

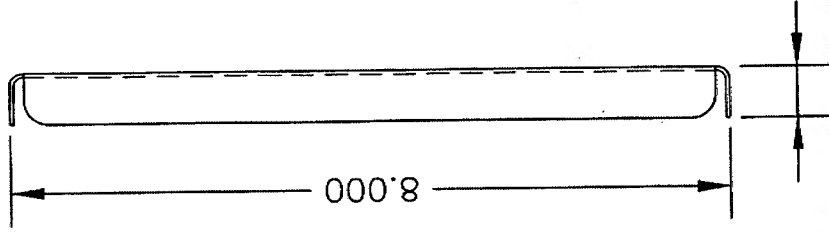
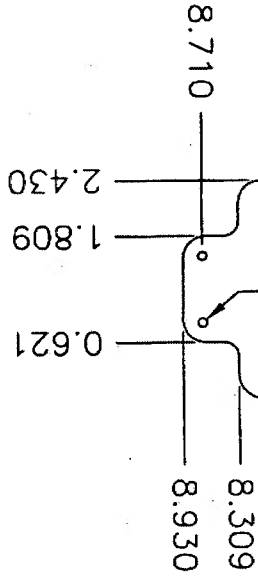
Measured by: FB	Audited by: S	Prototype Approval:	N/A
Date: 8-4-16	Date: 08/04/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	[Signature]



DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	BW	VICTORIA INTERNATIONAL AIRPORT, CANADA	
APPROVED		DRAWING NO.	REV. A
		D2606	SHEET 1 OF 1
DATE	TITLE		
97.10.23	CONSOLE BRACKET		
A	97.10.23	D2606 WAS D206-547-27	
A1	02.06.04	ADD FINISH	

RELEASED
97.11.04 KE
TSR A421



FLAT PATTERN

GRAIN
45°
08.04.16

MATERIAL: 2024-T3 (00-A-250/4) 0.040 THICK
PROFILE CONTROLLED BY FOLIO H2606
BEND RADIUS 0.093
FINISH: CHEMICAL CONVERSION COAT PER DART Q01 005 41

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38590